

Date: Thursday, 01/05/2008 4:16:43 PM
 User: Julie Lecocq

Process Sheet

| | | | | | | |
|-----------------------|---------------------------------------|-----------------------|------------------|----------------|------|-------------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : HEAD REST | | |
| Job Number | : 38972 | | Part Number | : D33033 | | |
| Estimate Number | : 10423 | | Drawing Number | : D3303 REV. B | | |
| P.O. Number | : | | Project Number | : N/A | | |
| This Issue | : 01/05/2008 | S.O. No. : | Drawing Revision | : B | | |
| Prsht Rev. | : NC | | Material | : | | |
| First Issue | : / / | Type : SMALL /MED FAB | Due Date | : 10/05/2008 | Qty: | 10 Um: Each |
| Previous Run | : 28126 | | | | | |
| Written By | : | | | | | |
| Checked & Approved By | : <u>JUL 08-5-02</u> | | | | | |
| Comment | : Est:A 04.09.07 New issue KJ/JLM | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|---|
| 1.0 | M2024T3S040 | 2024-T3 .040 sheet 3.7 |
| | | HB 8-5-7 Batch: <u>107572</u> HB 8-5-13 |
| Comment: Qty.: 0.3135 sf(s)/Unit Total : 3.1353 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) | | HB 8-5-13 Batch: <u>107572</u> HB 8-5-13 |
| 2.0 | WATER JET | FLOW WATER JET B HB 8-5-7 HB 8-5-B |
| Comment: FLOW WATER JET | | HB 8-5-7 HB 8-5-B |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE HB 8-5-13 HB 8-5-7 |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | HB 8-5-7 |
| 4.0 | QC8 | SECOND CHECK S08/05/13(x10) |
| Comment: SECOND CHECK | | S08/05/13(x10) |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 ml08/05/13(x10) |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Deburr HB 8-5-7 2- C'sink nut plate holes as per Dwg D3303 3-polish waterjet marks | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|--------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 8/1/05 | # | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 4:16:43 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 38972

Part Number: D33033

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



To Fit AT9011



(Ph)

Comment: NC BRAKE

Form as per Dwg D33033 ~~To Fit AT9011~~ 00.05.13

SB 08/05/13

(10)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Sodastyle

x10



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005.4.1

JF/FL 08/05/14

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



EL



Comment: INSPECT CHEMICAL CONVERSION COAT

08-05-14

x10

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: #38969

AS 08/05/14

x10

11.0 QC21 FINAL INSPECTION/W/O RELEASE



08/05/14 A

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.05.14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3303-3 PAR #: N/A Fault Category: Prod / Prod Ass' Med Small NCR: Yes No DQA: AD Date: 08/05/14
 QA: N/C Closed: AD Date: 08/05/15

| NCR: 38912 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|-------|--|-----------------------------|--|-----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08/05/13 | # 6.0 | 10 parts broke/cracks During Bending Was To fit on pt901 | /star | Scapp and Destroy and Replace Qty 10 B# 107572 | 213 08/05/13 | () 08/05/13 | /star | 08/05/13 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 389T2 |
| Description: Head Rest | Part Number: | D3303-3 |
| Inspection Dwg: D3303 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

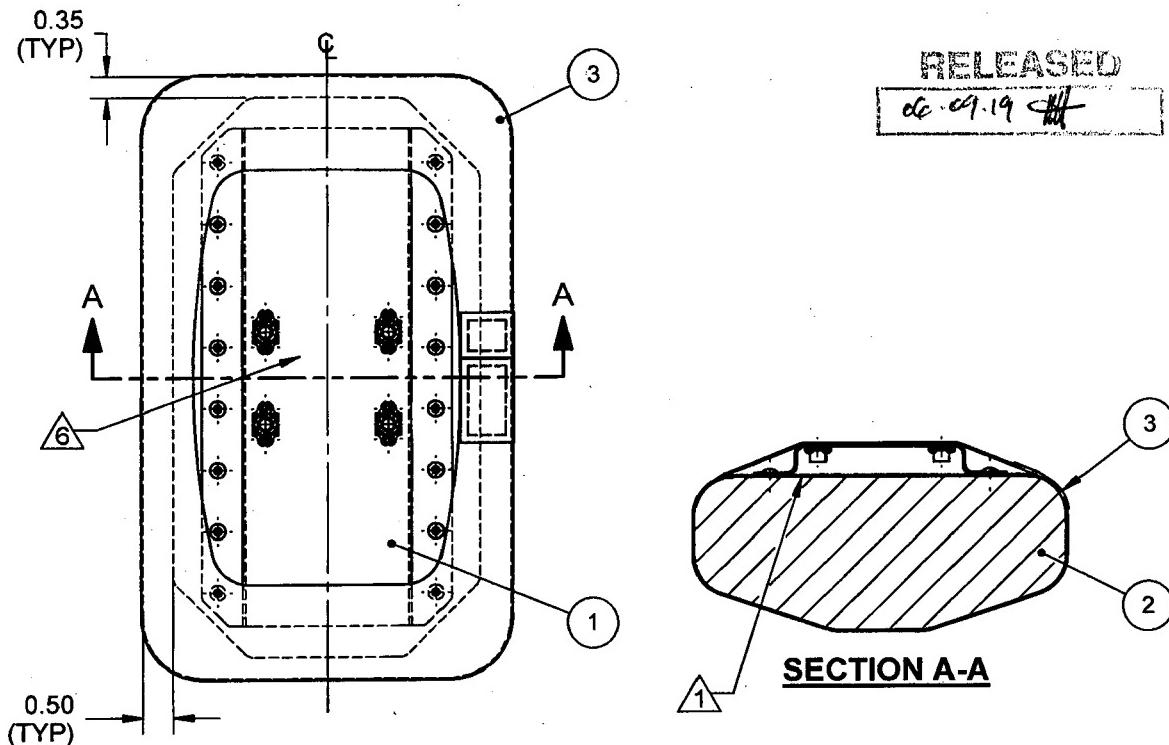
| | | | | | |
|--------------|-------|-------------|----------|---------------------|-----|
| Measured by: | HR | Audited by: | C | Prototype Approval: | N/A |
| Date: | 8-5-7 | Date: | 08/05/07 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.09.08 | New Issue | KJ/JLM | SJL |

DART

| | | | | |
|-------------------------|-----------------------|--|--------------|--------------|
| DESIGN <i>RF</i> | DRAWN BY <i>BS</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED <i>PH</i> | APPROVED <i>HF</i> | DRAWING NO. D3303 | REV. B | SHEET 1 OF 4 |
| DATE 06.08.17 | | TITLE HEAD REST | SCALE 1:3 | |

| | | |
|-----------------|-------------------------|--|
| REV A | DATE 04.08.18 | DESCRIPTION NEW ISSUE |
| REV B | DATE 06.08.17 | DESCRIPTION UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE |



D3303-041 HEAD REST

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|------------------|
| | X | D3303-041 | HEAD REST |
| 1 | 1 | D3303-043 | BRACKET ASSEMBLY |
| 2 | 1 | D3305-1 | FOAM |
| 3 | 1 | D3306-041 | COVER ASSEMBLY |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38972

NOTES:

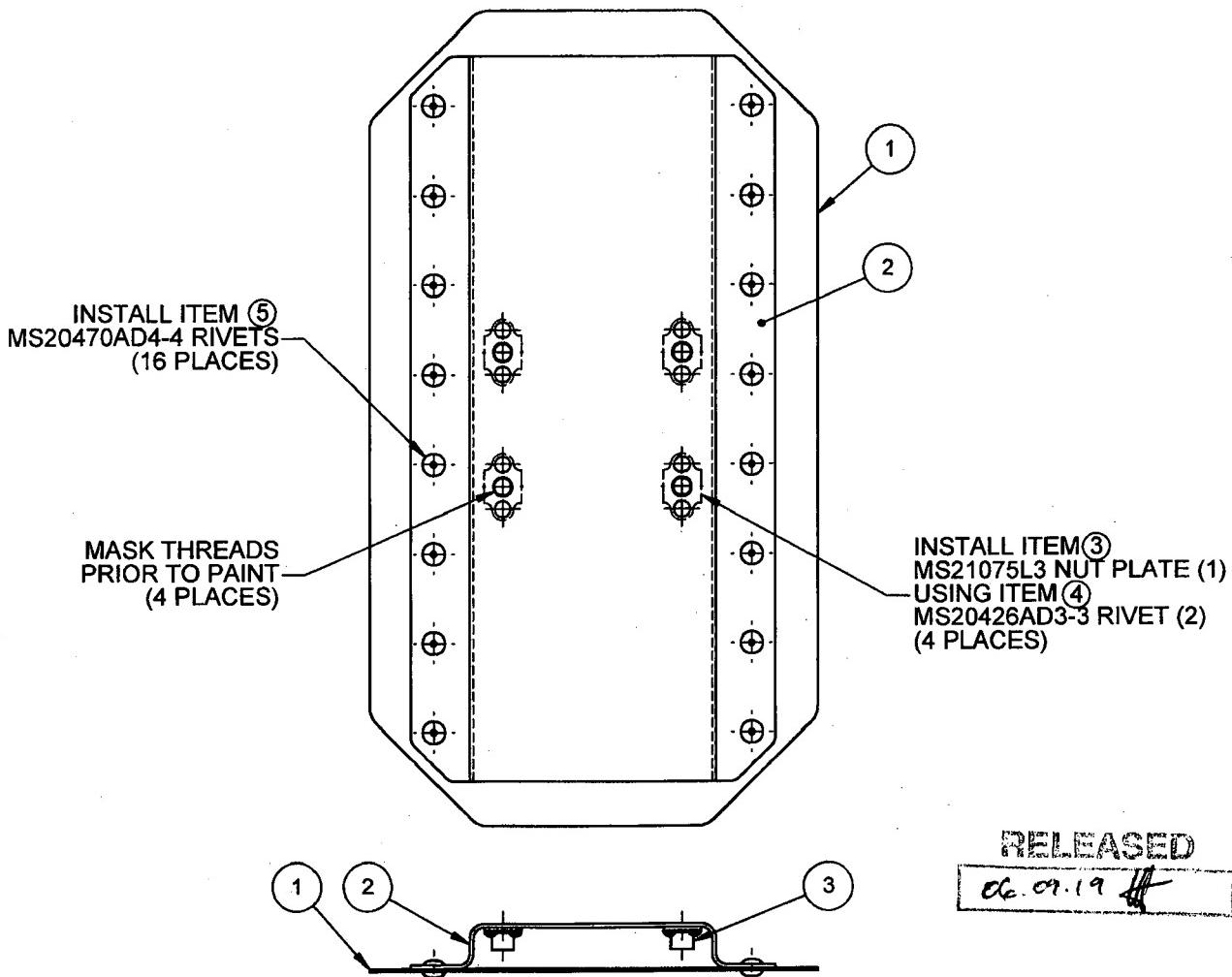
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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DART

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>RF</i> | DRAWN BY <i>AS</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>CH</i> | DRAWING NO. D3303 | REV. B SHEET 2 OF 4 |
| DATE 06.08.17 | TITLE HEAD REST | SCALE 1:2 | |



RELEASED

06.09.19 *ff***D3303-043 BRACKET ASSEMBLY**

| ITEM | QTY -043 | P/N | DESCRIPTION | UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. <i>38972</i> |
|------|-------------|--------------|------------------|---|
| | X | D3303-043 | BRACKET ASSEMBLY | |
| 1 | 1 | D3303-1 | PLATE | |
| 2 | 1 | D3303-3 | HEAD REST | |
| 3 | 4 | MS21075L3 | NUT PLATE | |
| 4 | 8 | MS20426AD3-3 | RIVET | |
| 5 | 16 | MS20470AD4-4 | RIVET | |

NOTES:

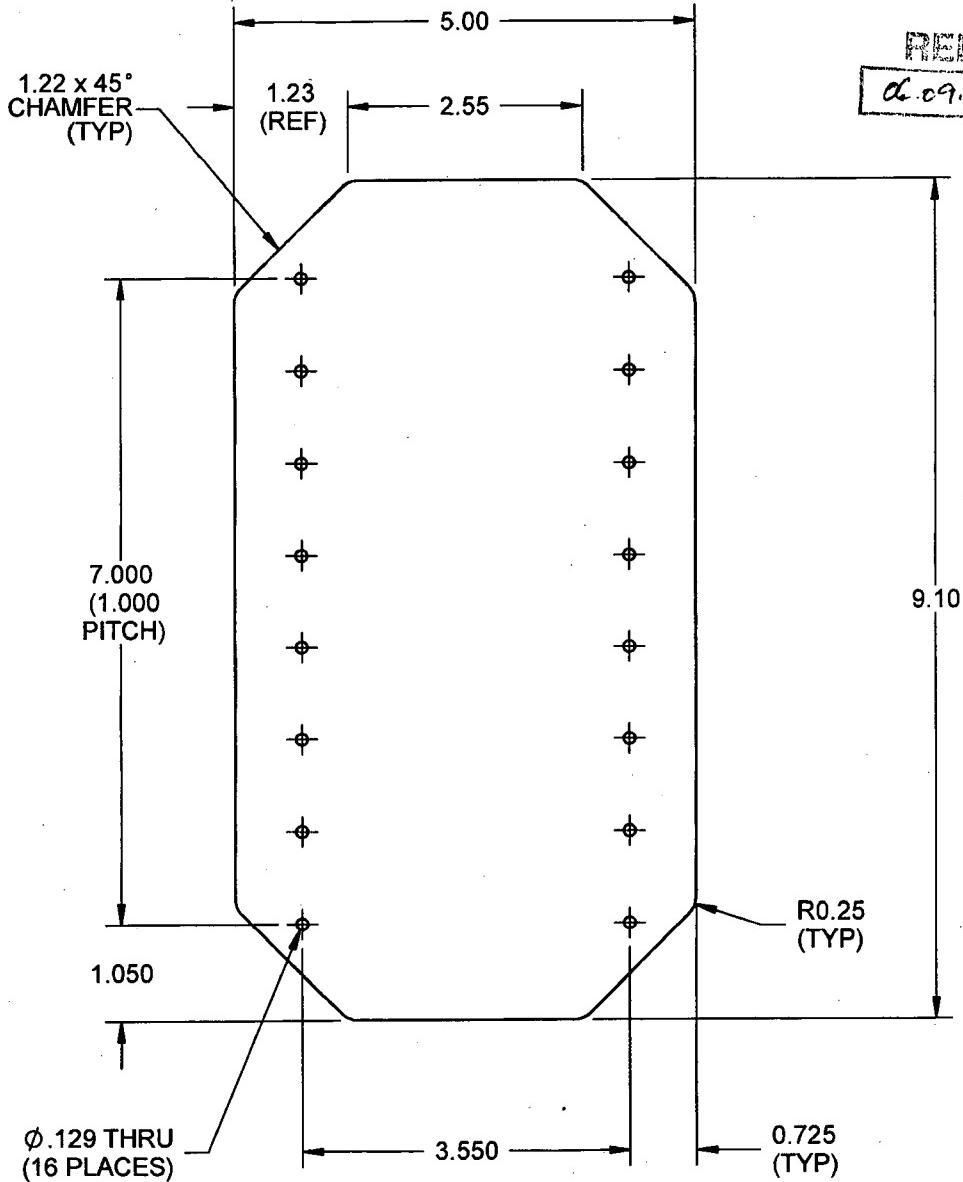
- 1) FINISH: POWDER COAT ASSEMBLY GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART

| | | |
|-------------------------|---------------------------|--|
| DESIGN <i>PF</i> | DRAWN BY <i>AS</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>PH</i> | APPROVED <i>JH</i> | DRAWING NO. D3303 |
| DATE 06.08.17 | TITLE HEAD REST | REV. B SHEET 3 OF 4 SCALE 1:2 |

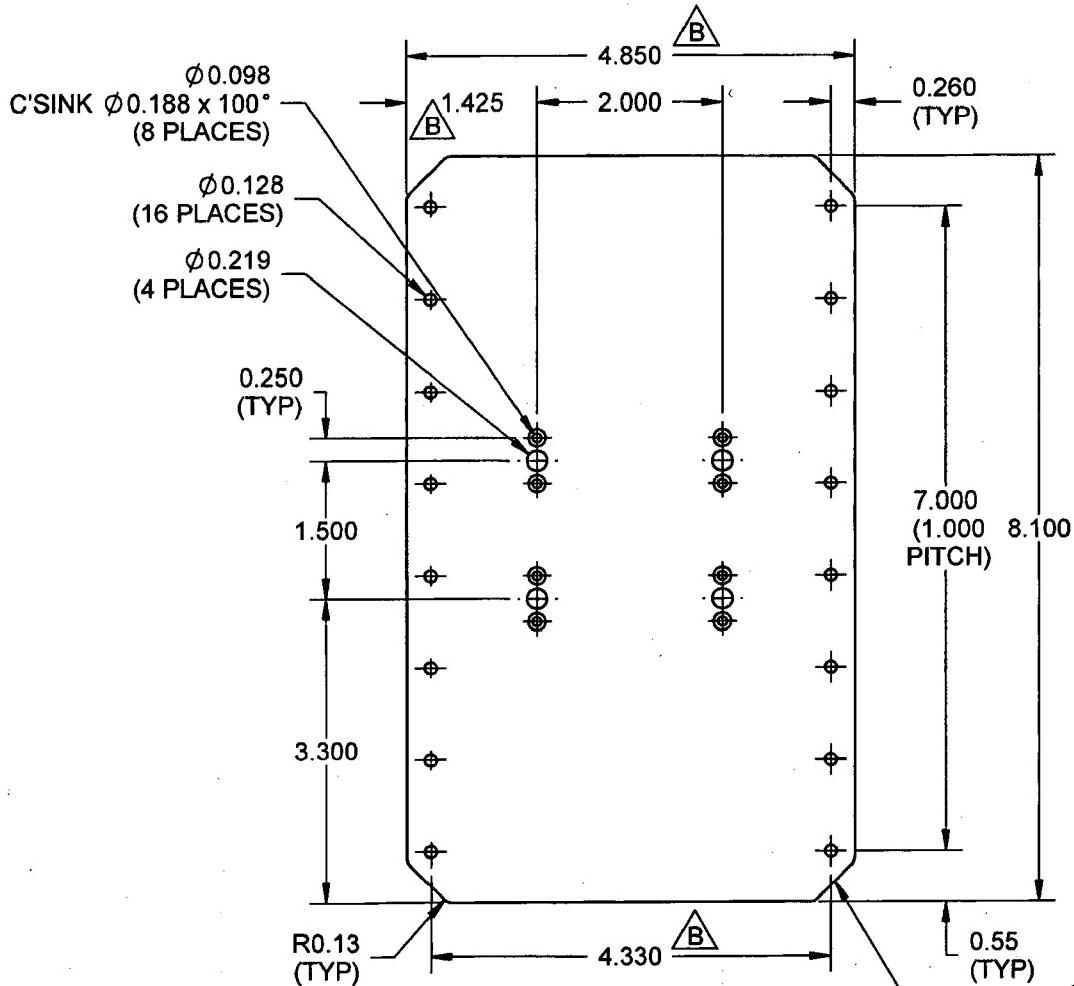
**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

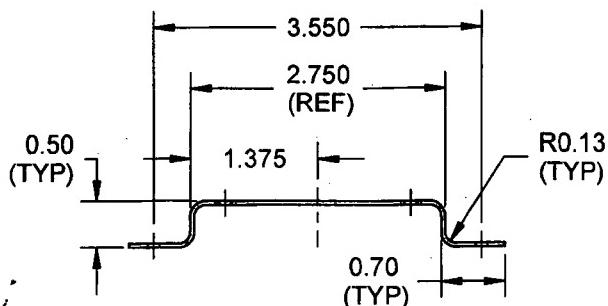
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38972

DART

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>RF</i> | DRAWN BY <i>JS</i> | DART AEROSPACE LTD - HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>HS</i> | DRAWING NO. D3303 | REV. B SHEET 4 OF 4 |
| DATE 06.08.17 | TITLE HEAD REST | SCALE 1:2 | |



RELEASED
06.08.17

**D3303-3 BRACKET BEND DETAIL****COPYRIGHT © 2004 BY DART AEROSPACE LTD**

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| | | |
|--------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 38977 |
| Description: HEAD REST | Part Number: | D3303-3 |
| Inspection Dwg: D3303-3 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------|------------------|--------|--------|----------------------|----------|
| .098 | +.005 - .001 | .101 | X | | | |
| .132 | +.005 - .001 | .132 | X | | | |
| .219 | +.005 - .001 | .222 | X | | | |
| .550 | +/- .010 | .550 | X | | | |
| .260 | +/- .010 | .260 | X | | | |
| 3.300 | +/- .010 | 3.303 | X | | | |
| 1.500 | +/- .010 | 1.499 | X | | | |
| .250 | +/- .010 | .250 | X | | | |
| R.12 | +/- .030 | .17 | X | | | |
| 2.000 | +/- .010 | 1.999 | X | | | |
| 1.425 | +/- .010 | 1.426 | X | | | |
| 8.100 | +/- .010 | 8.103 | X | | | |
| 7.000 | +/- .010 | 7.6595 | X | | | |
| 1.000 | +/- .010 | 1.000 | X | | | |
| .040 | +/- .010 | .039 | X | | | |
| 4.850 | +/- .010 | 4.854 | X | | | |
| 4.330 | +/- .010 | 4.333 | X | | | |

| | | | | | |
|--------------|--------|-------------|--------|---------------------|--------|
| Measured by: | BB | Audited by: | J | Prototype Approval: | N |
| Date: | 8-5-13 | Date: | 8/5/13 | Date: | 8/5/13 |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |